

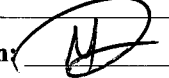
Work Order ID 126923

126923

Page 1

Monday, December 01, 2014 11:33:31 AM

Item ID: D3822-1KGY Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Vertical Tunnel, LH
Start Date: 11/27/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/02/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan:  Date: 12/2/14 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3822-1	Rev. C

100	0.00								DAS 07 9-89
-----	------	--	--	--	--	--	--	--	-------------------

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

12/12/14

105

105

HandThermo

Dry Material

Memo

0.00

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

DAS
07
9-89

12/12/14

Temp: 150 deg. F

Time IN: 5:00 PM

Time OUT: 6:00 AM

DEC 15 2014

Per.....

Work Order ID 126923

Monday, December 01, 2014 11:33:31 AM

126923

Page 2

Item ID: D3822-1KGY

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Vertical Tunnel, LH

Start Date: 11/27/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/02/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Thermoform

Memo

0.00

~~Thermoforming Machine~~~~1-Machine Set-Up~~~~2-Pre-heat Tool to required temp.~~~~3-Thermoform as per Dwg and Folio #FTA025 using tool DT9073~~Dwg Rev: CFolio Rev: B

Visually inspect for proper formation of each part

140

0.00

140

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

DAS

07

9-89

14/12/16

14/12/18

Work Order ID 126923***126923***

Page 3

Monday, December 01, 2014 11:33:31 AM

Item ID: D3822-1KGY

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Vertical Tunnel, LH

Start Date: 11/27/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/02/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 07 9-89
150									
QC	Memo	0.00							
Quality Control	Complete FAI document								14/12/18

160 QC5- Inspect part completeness to step on W/O 0.00

160

QC

Memo

0.00

Quality Control

DAS
38
9-89

DEC 18 2014

170 Identify as per dwg & Stock Location: _____ 0.00

170

Packaging

Memo

0.00

Packaging

DAS
06
9-89

12/26/17

Picklist Print

Monday, December 01, 2014 11:33:31 AM

Page 1

Work Order ID: 126923

126923

Parent Item: D3822-1KGY

D3822-1KGY

Parent Item Name: Vertical Tunnel, LH

Start Date: 11/27/14

Required Date: 12/02/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

IPP Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-52068		Purchased		No		100	sf	3,800.000	7.8	8			DAS 07 9-89

MKYD6185S 080-P3-52068

Kydex steel grey (52"x96"-.080)

Location	Loc Qty	Loc Code
LAIRD	1180	
m129546	347	
m129760	347	
m130383	486	
therm	2620	
119476	61	
121902	819	
122181	1046	
m127759	347	
m128321	347	

8 sg ft.

17/12/18

DART AEROSPACE LTD		Work Order:	126923
Description: Vertical Tunnel, LH		Part Number:	D3822-1KIV/KGY
Inspection Dwg: D3822	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DAS
07
9-89

Date: 14/12/16

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.8	Min	0.97"	✓			
0.3	Min	0.307"	✓			
0.55	Min	0.66"	✓			
0.040	Min	0.060"	✓			
0.050	Min	0.062"	✓			

Measured by: DAS
07
9-89

Date: 14/12/16

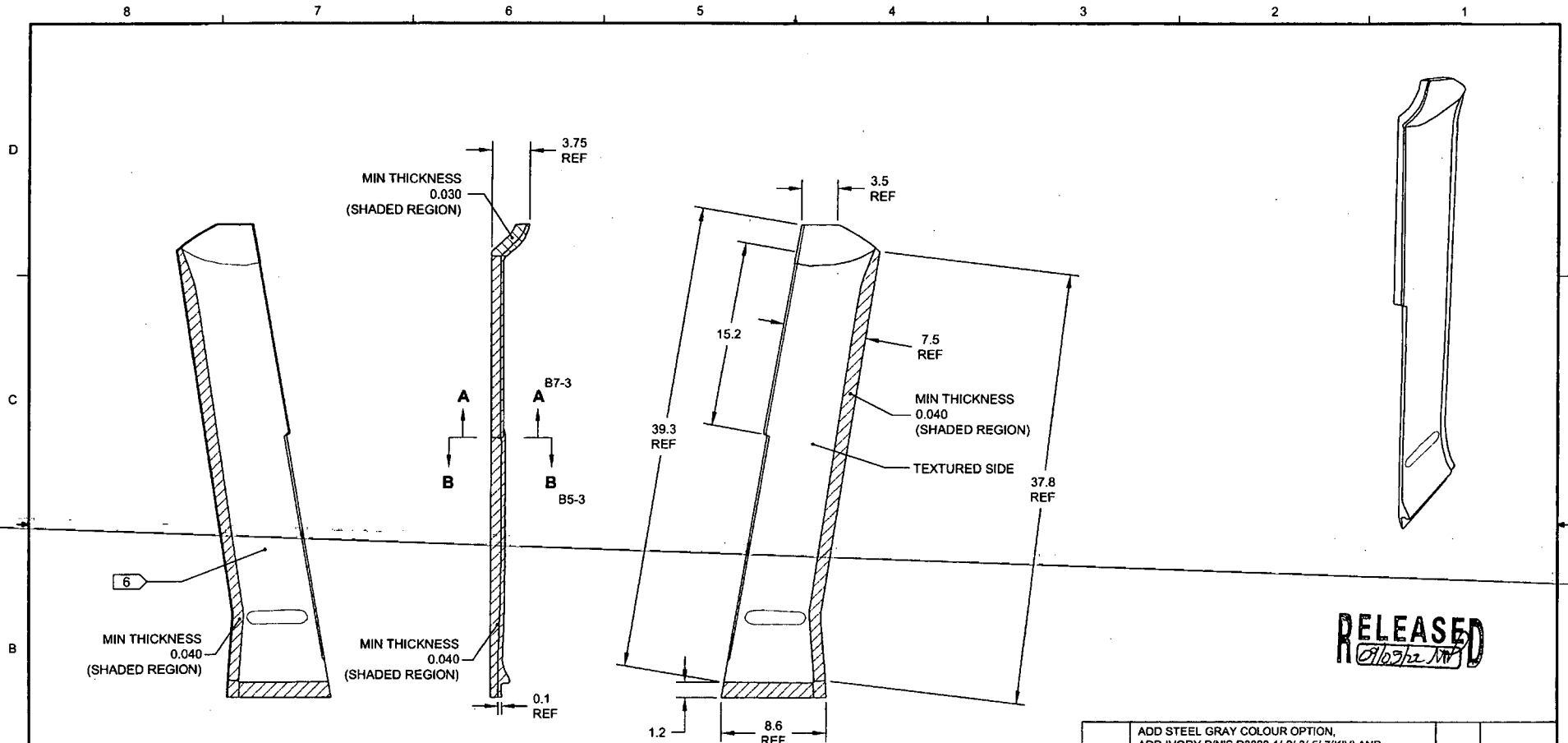
Audited by: 38
9-89

Date: DEC 18 2014

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	



D3822-1 VERTICAL TUNNEL, LH
(BELL 206 A/B)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9073 PER DART QSI 022. TRIM PER MOLD.
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3822-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N'S D3822-1/2/3/5/7(KIV) AND ADD STEEL GRAY P/N'S D3822-1/2/3/5/7(KGY) (ZN A5-1, A5-2, A5-4, A5-5, A5-6)	PH	09.05.05
B	37.8 WAS 38.8 (ZN C8-4); MODIFY TOP OF -3 AND ADD VIEW J (ZN A3-4); INCREASE JOGGLE ON -3 (ZN C6-4); UPDATE VIEW F (ZN A1-4); REASON: TO IMPROVE FIT OF D206-781-151 KIT	PH	09.02.09
A	NEW ISSUE	PH	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3822
TITLE VERTICAL TUNNEL (BELL 206 A/B)
REV. C
SHEET 1 OF 6
SCALE NTS
COPYRIGHT © 2008 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.